

Aero Design Ltd.**Work Order Control Sheet**

Work Order#: 2016-102 Date Opened: 05 August 2016 Title: Fabrication

Aircraft OEM: Bell Aircraft Model: 206B/206L/407 Product Type: Cyclic Friction Product Model: Cap Quantity: 50**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95224	1	Cyclic Friction Cap	JC

Traveller

CNC machine bottom side
Face end to length
Turn OD to step
Deburr

Initial or N/A

JC
DB
DM
DM

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

49*
N/A
N/A
JC

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
JC
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Notes

* 1 part used to check fit of ID mid process.

Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Print: Jeff Clarke

Print: Jason Rekve

Print: Jeff Clarke

Sign:

Sign:

Sign:

Form 2010.03

SCA: AD02

SCA: AD01

SCA: AD02

Date: 09-Aug-16

Date: 09-Aug-16

Date: 09-Aug-16

Rev. Original 23 Sep 2014

Approved Manufacturing Facility 73-04

2016-102

Bell 206/407 Cyclic Friction Cap PN 95224

Drawing Number: 95224

Material PO# 12074 / 16002

Cut 5/8" diameter stainless steel blanks to 9/16" long ✓

Load CNC fixture ✓

Run CNC program to turn bottom cup side ✓

Ensure ID is press fit on tubes ✓

Load part in lathe using 7/16" collet ✓

Face to Length IAW drawing 95224 ✓

Turn diameter of top nub, face collar on final pass ✓

Champher Edges ✓

Scotchbrite O.D. of Collar ✓

Deburr I.D. of hole ✓

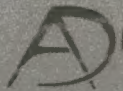


WO# 2016-102

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: CAP

No. of pieces: 49

Manufacturer: AERO DESIGN

Part No.: 95224-01

Serial No.: PD 12014 / 16002

TTSN: N/A

TSO: N/A

Rem.: N/A

Work Order No.: 2016-102

Remaining Tasks to be Performed: INSTALL

Signature: [Signature]

Date: 09 AUG 2016

Lic. No. / SCA

Form# 20.E.02

Rev. 1 24 April 2014

Serviceable



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AMF 73-04

Remarks

Serviceable

Y50

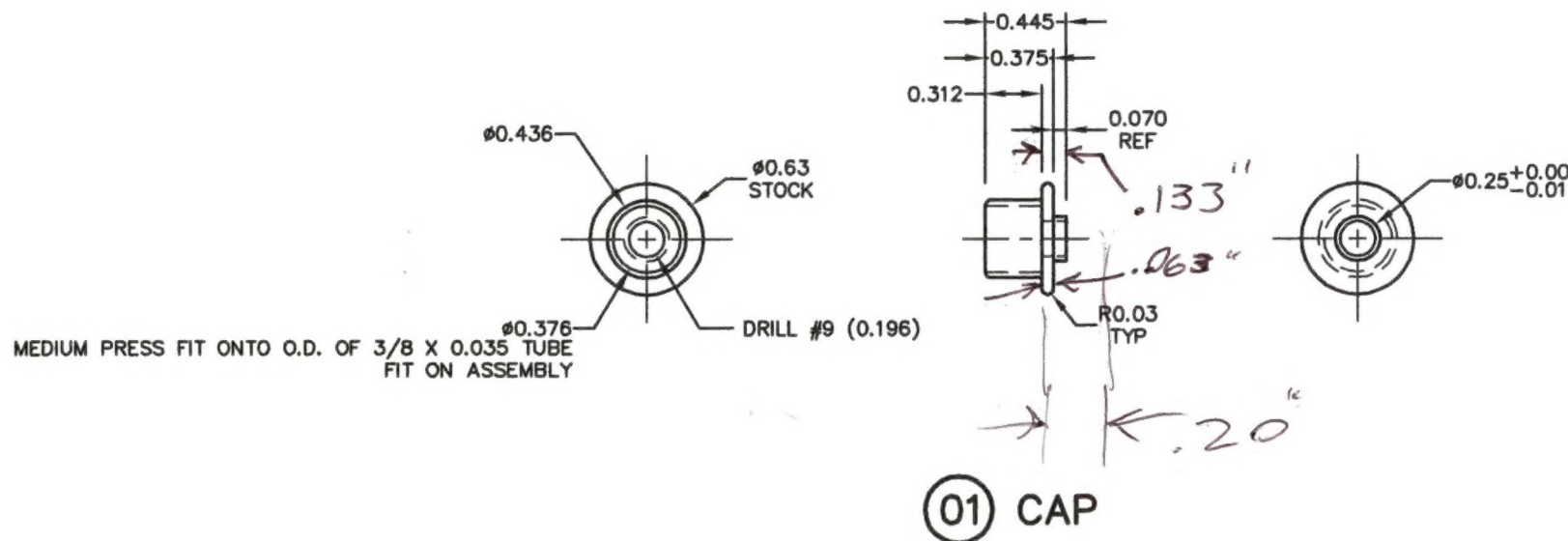
-1 test fit ID


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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; STOCK SIZE CHANGED	BJC	21/03/2014

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.



95224-01		01	CAP	304 STAINLESS STEEL	ASTM A479	#0.625 ROD							
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE							
QTY	LIST OF MATERIALS												
				APPROVALS		DATE			AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G8 TEL: 604.403.2376 www.aerodesign.ca				
				DRAWN: JEFF CLARKE		18 OCT 2012							
				CHECKED: E. BURGON									
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				BELL 206A, 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - CAP					
								SCALE 1 : 1		DWG. SIZE		DWG. NO.	
				SHEET 1 OF 1		A4		95224		1			



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AMF 73-04

Nomenclature: CAP No. of pieces: 49

Manufacturer: AERO DESIGN

Part No.: 95224-01 Serial/Batch No.: P0 18074 / 16002

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2016-102

Remaining Tasks to be Performed: TURN TOP END, INSPECT ^{AD 05} _{✓AD002}

Signature: Jff Clch.

Date: 05 AUG 2016 Lic. No. / SCA AD002

In Process



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AMF 73-04

In Process

Remarks
